

DESIGN <i>13</i>	DRAWN BY <i>13</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 1 OF 7
5.02.07		TITLE HANDLE WELDMENT	SCALE 1:8
05.02.07		NEW ISSUE	

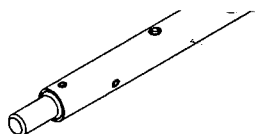
DALE,
THIS IS PAPERWORK
FOR D206-731-011
GHW PROTOTYPE



STD. BLACK VINYL GRIP,
1,000 I.D. x 4.75 LONG.
POSSIBLE SUPPLIER,
REID TOOLS SUPPLY CO.
P/N GP-1R (1)

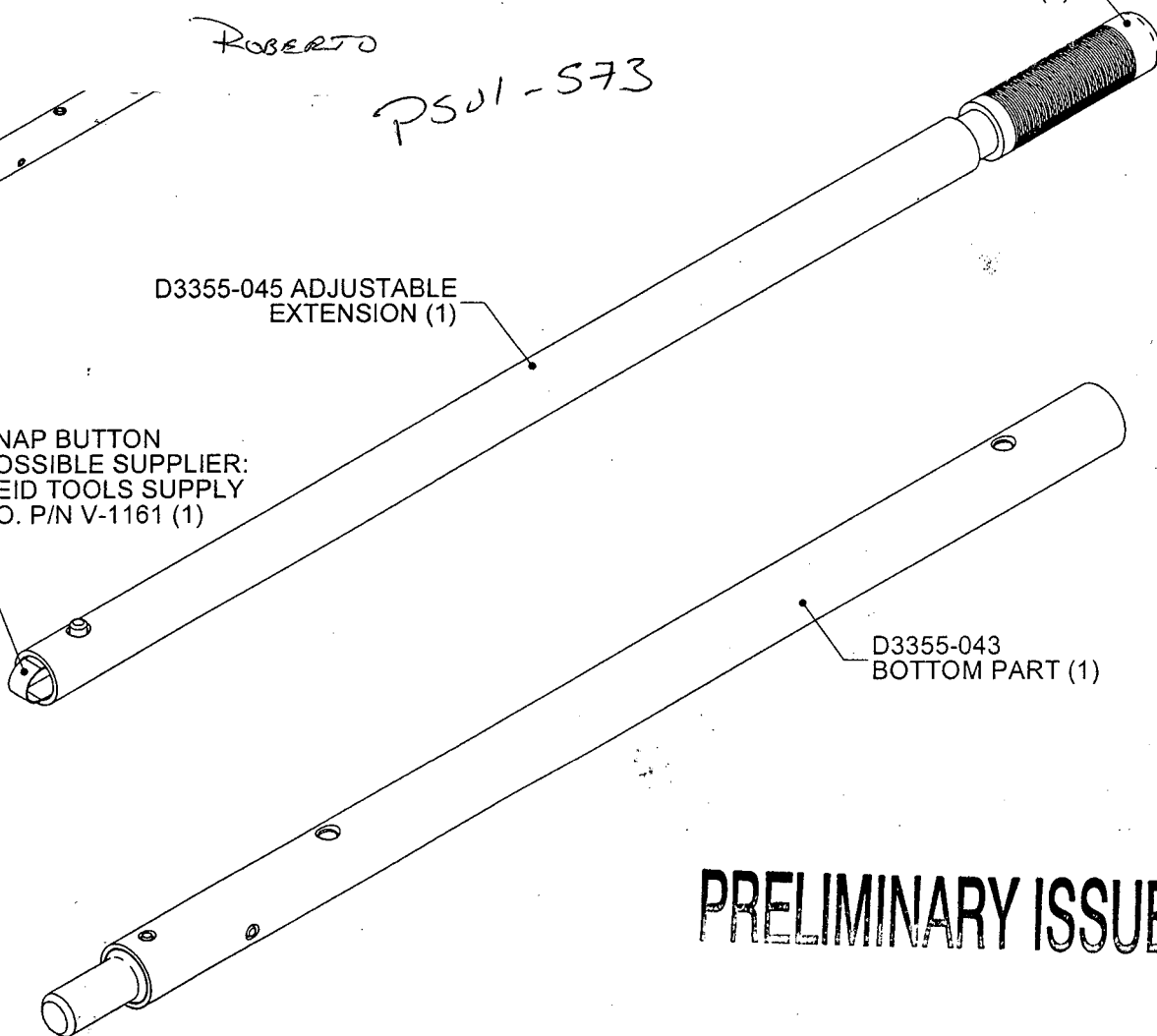
ROBERTO

PS01-573



D3355-045 ADJUSTABLE
EXTENSION (1)

SNAP BUTTON
POSSIBLE SUPPLIER:
REID TOOLS SUPPLY
CO. P/N V-1161 (1)



D3355-043
BOTTOM PART (1)

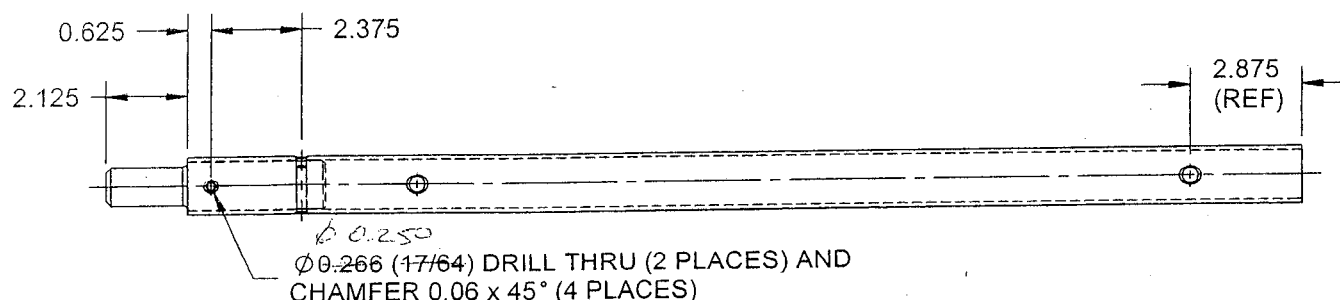
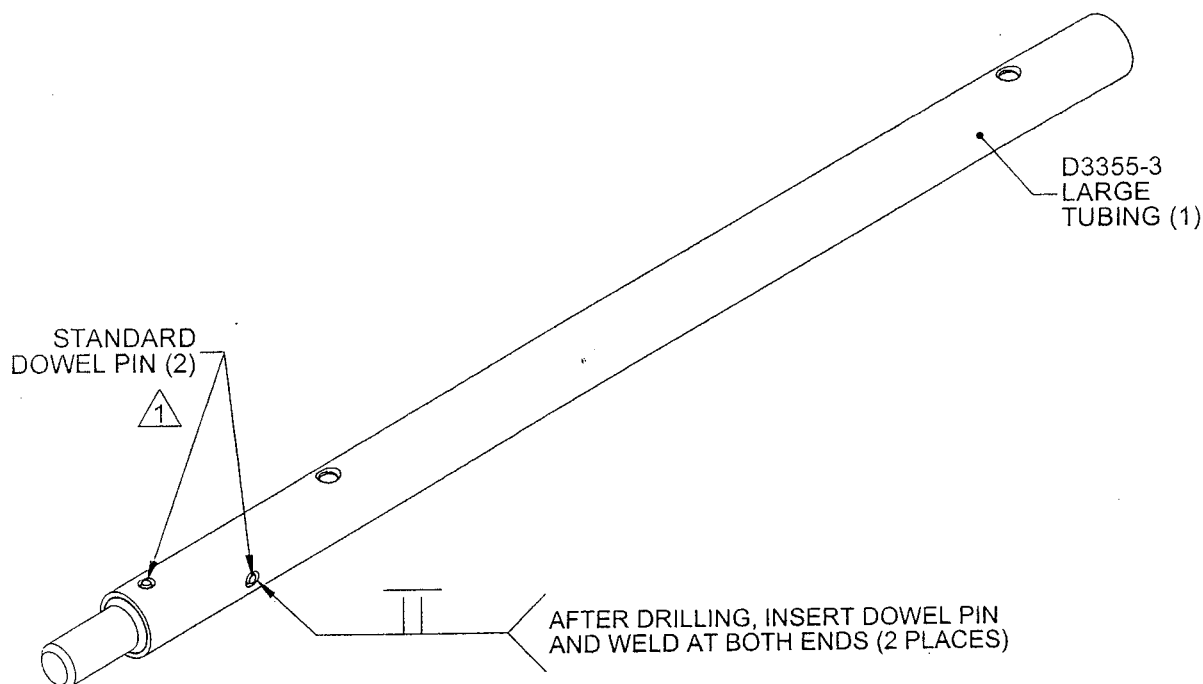
PRELIMINARY ISSUE

D3355-041 HANDLE ASSEMBLY

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CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 2 OF 7
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:5



PRELIMINARY ISSUE

D3355-043 BOTTOM PART

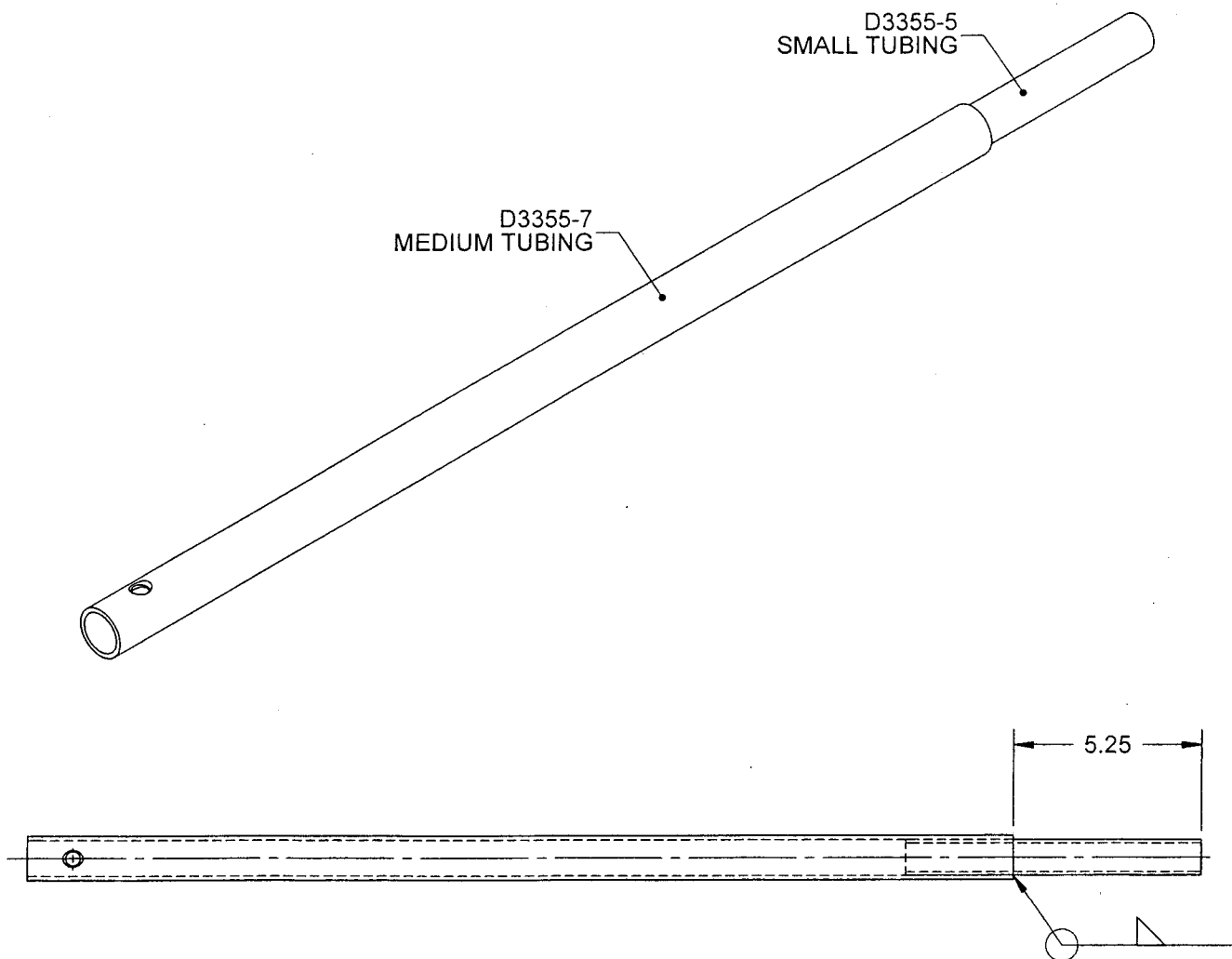
NOTES:

- 1) STEEL STANDARD GROUND DOWEL PIN, Ø0.250 X 1.25 LONG.
POSSIBLE SUPPLIER: SPAENAUR, P/N 238-042-043 *#05.04.07*
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 3 OF 7
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:5



PRELIMINARY ISSUE

D3355-045 ADJUSTABLE EXTENSION

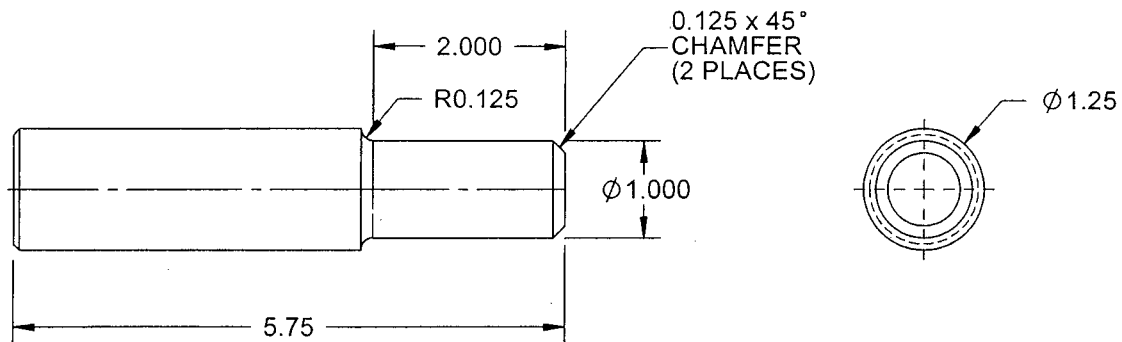
NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 4 OF 7
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:2



PRELIMINARY ISSUE

D3355-1 HANDLE TIP

NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR, $\phi 1.250$
(REF. DART SPEC. M303R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

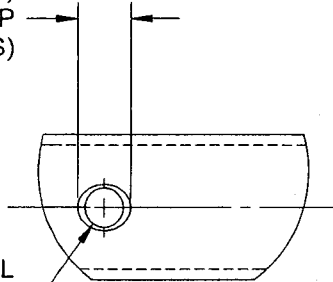
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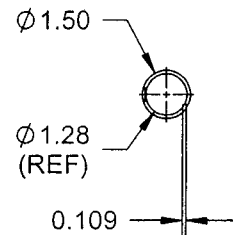
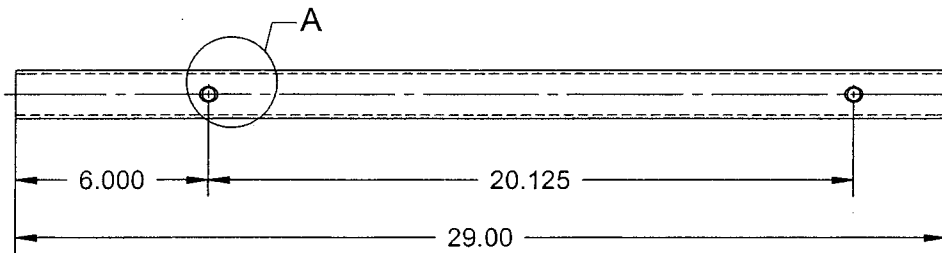
DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 5 OF 7
DATE 05.05.07		TITLE HANDLE WELDMENT	SCALE 1:6

CHAMFER $\phi 0.562$ (9/16)
x 45°, 0.078 DEEP
(2 PLACES)

$\phi 0.406$ (13/32) DRILL
THRU (2 PLACES)



DETAIL A
SCALE 1 : 2



PRELIMINARY ISSUE

D3355-3 LARGE TUBING

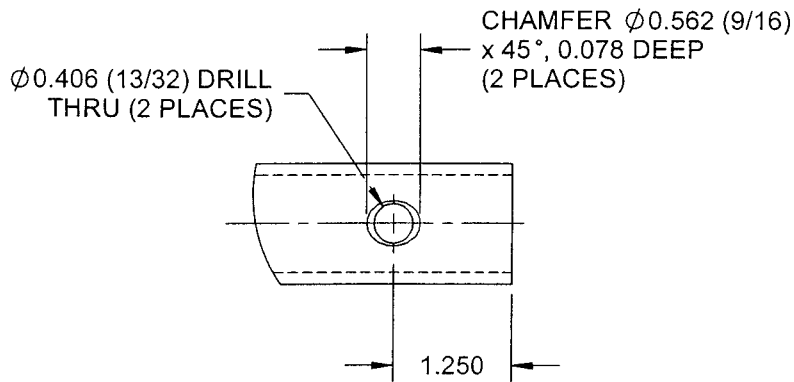
NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

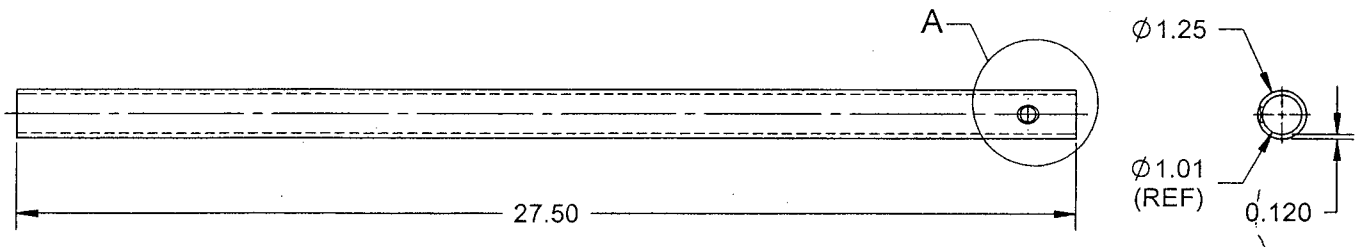
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DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 6 OF 7
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:5



DETAIL A
SCALE 1 : 2



PRELIMINARY ISSUE


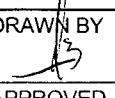
D3355-5 MEDIUM TUBING

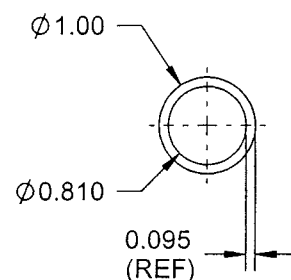
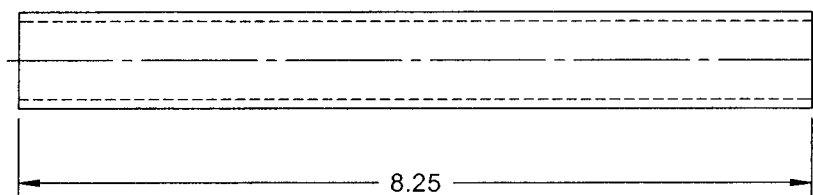
NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 7 OF 7
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:2



PRELIMINARY ISSUE

D3355-7 SMALL TUBING

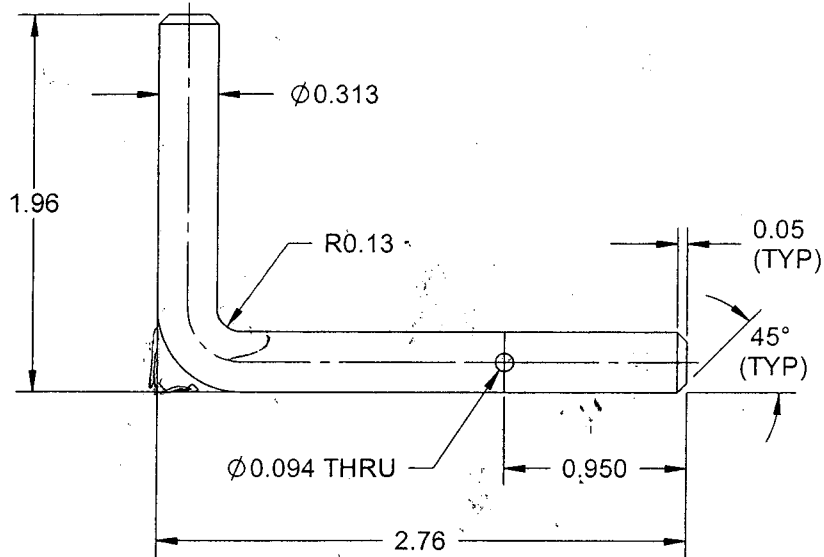
NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED	APPROVED	DRAWING NO. D3356	REV. A SHEET 1 OF 1
DATE 04.12.13	TITLE PIN		SCALE 1:1



PRELIMINARY ISSUE

FLAT LENGTH: 4.26

D3356-1 PIN

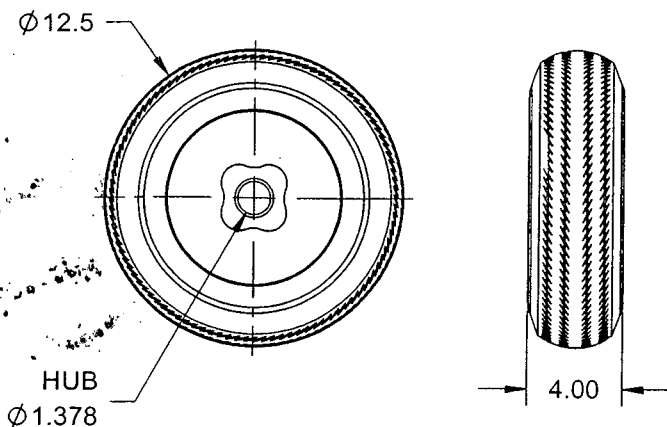
NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR STAINLESS STEEL
(REF. DART SPEC. M303R0.313))
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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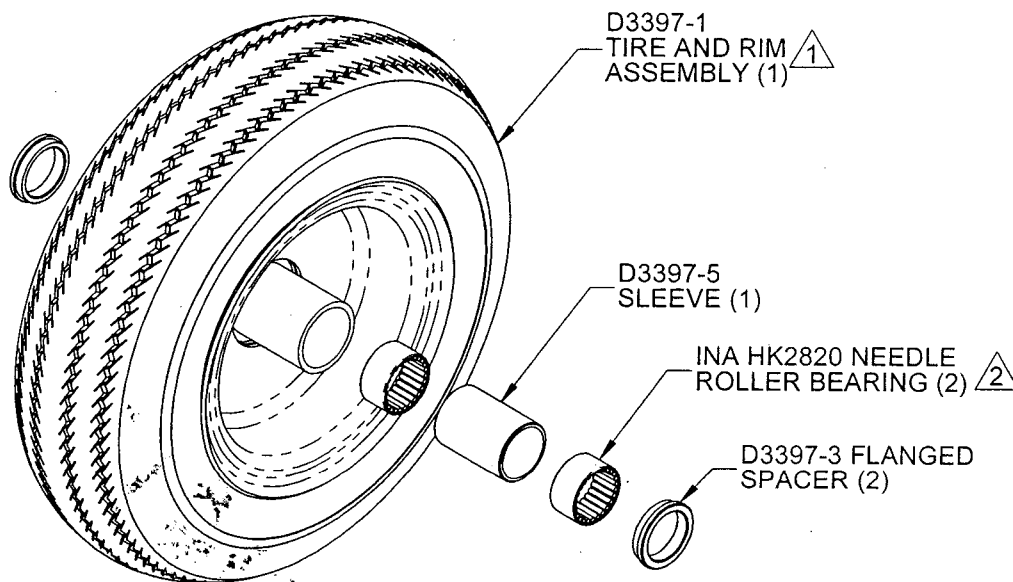
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3397	REV. A SHEET 1 OF 1
DATE 05.02.10		TITLE 12.5" WHEEL ASS'Y	SCALE 1:8
A	05.02.10	NEW ISSUE	



1 D3397-1 TIRE AND RIM ASS'Y

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATATION LOAD
TIRE: $\phi 12.4 \times 4.1$ RIM: $\phi 6.0 \times 4.0$	445 LBS	50 PSI*

SHIM STOCK
AT 1235 .004
SHIM .002 X 45 STRIPES
BOLT S/F 37



26.02.10

PRELIMINARY ISSUE

D3397-041 12.5" WHEEL ASS'Y

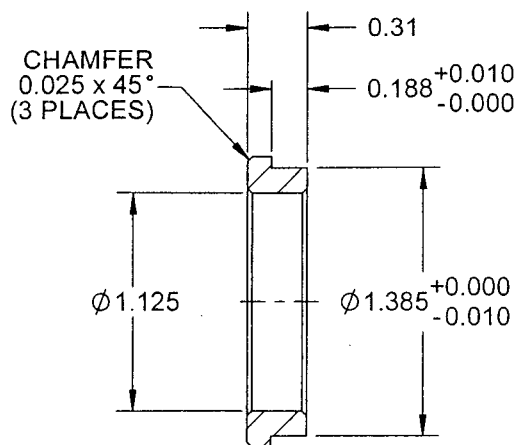
NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

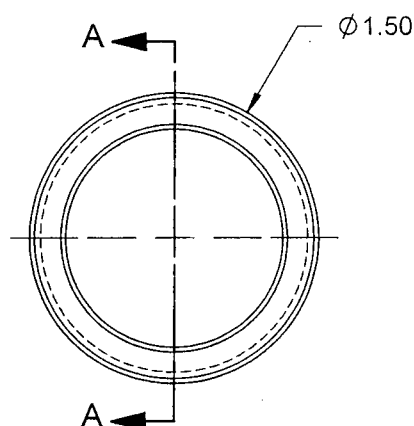
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CHECKED	APPROVED	DRAWING NO. D3397	REV. A SHEET 2 OF 3
DATE 05.02.10		TITLE 12.5" WHEEL ASS'Y	SCALE 1:1



SECTION A-A



PRELIMINARY ISSUE

D3397-3 FLANGED SPACER

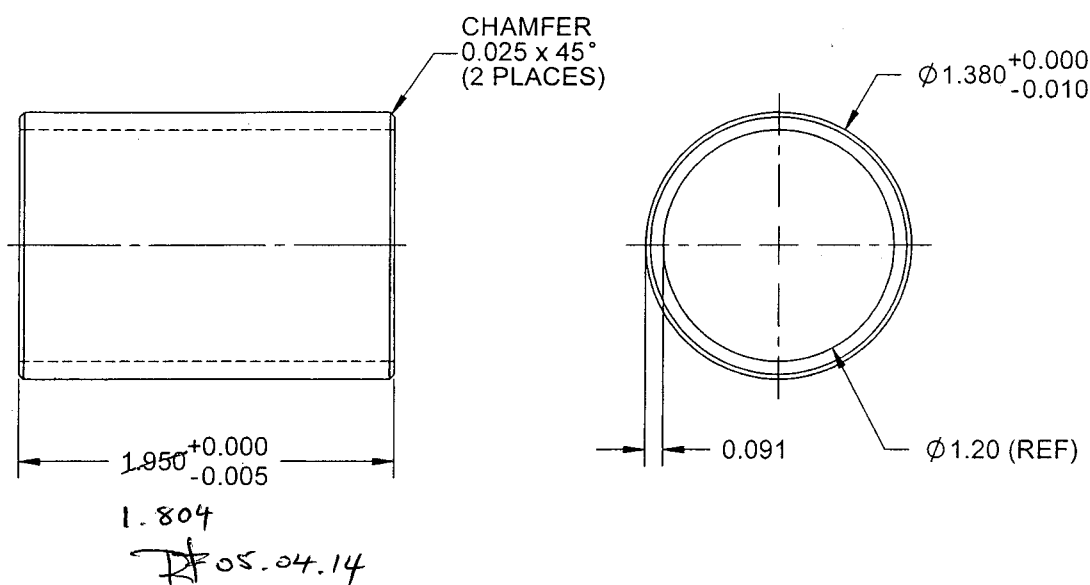
NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED	APPROVED	DRAWING NO. D3397	REV. A SHEET 3 OF 3
DATE 05.02.10		TITLE 12.5" WHEEL ASS'Y	SCALE 1:1



PRELIMINARY ISSUE

D3397-5 SLEEVE

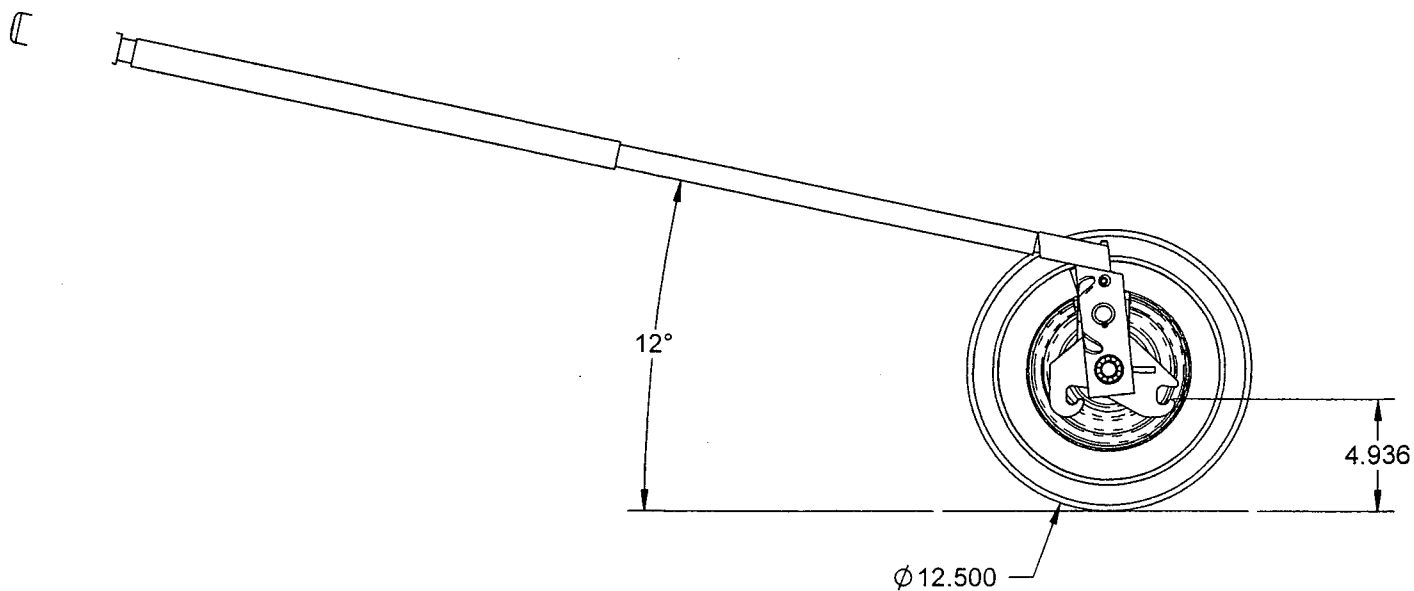
NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D206	REV. A SHEET 2 OF 3
DATE 05.02.02	TITLE GH WITH 12.5" WHEELS		SCALE 1:8.5

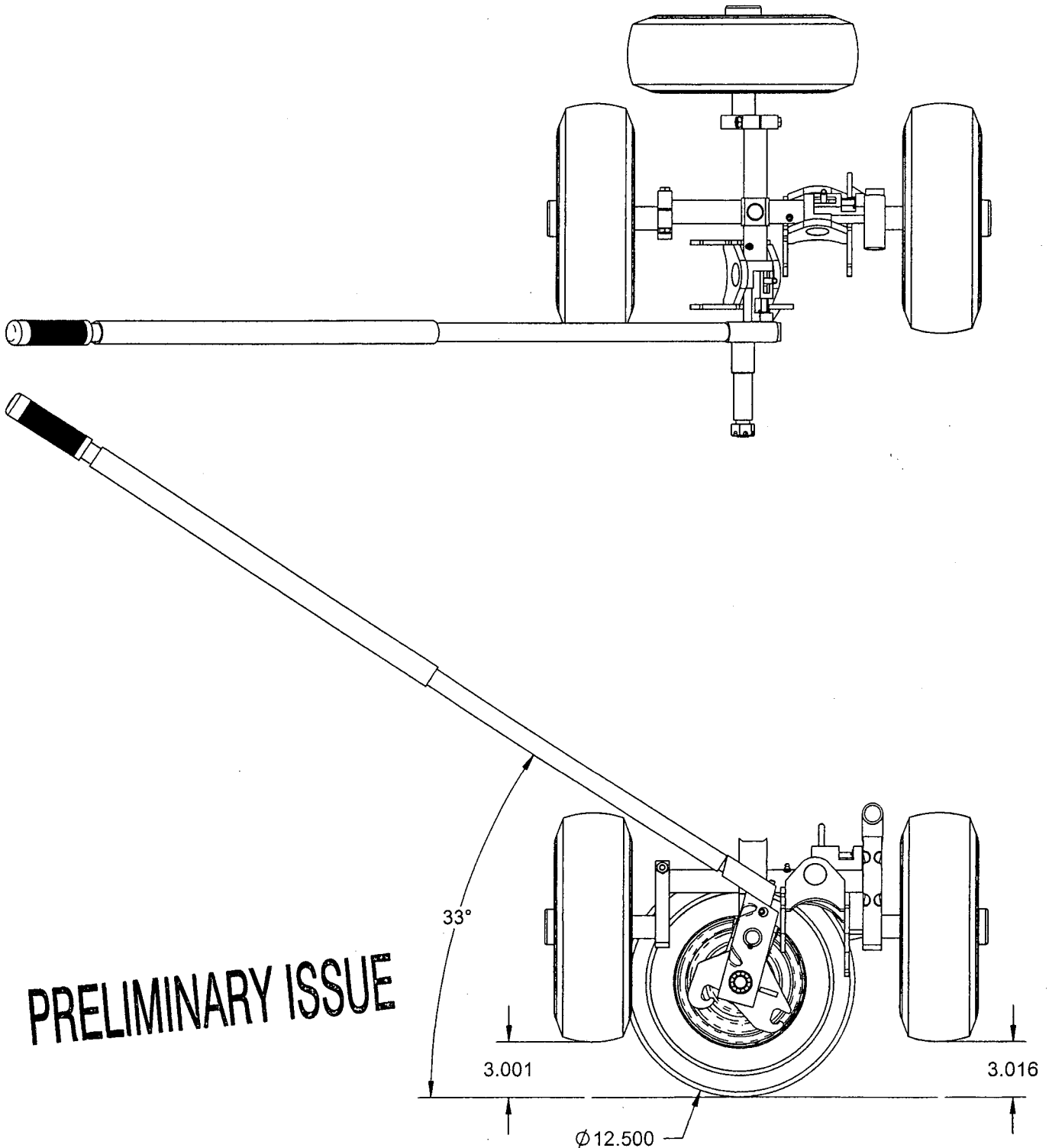


PRELIMINARY ISSUE

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D206	REV. A SHEET 1 OF 1
DATE 05.02.02	TITLE GH WITH 12.5" WHEELS		SCALE 1:8
A	05.02.02	FOR REFERENCE ONLY	



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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			1
1	MFA	FABRICATE SMALL TUBING AS PER DWG 3355-7 (M1018 TRI.000 W.095)			1
		BATCH: M16999	CPL	05/04/08	1
2	MFA	DEBURR	CPL	05/04/08	1
B	MFA	WELD			
H	MFA	D3358-041 HANDLE ASS			

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3353	REV. A SHEET 8 OF 10
DATE 04.12.13	TITLE LUG WELDMENT		SCALE 1:2

Part # **M1020TR1.250W**

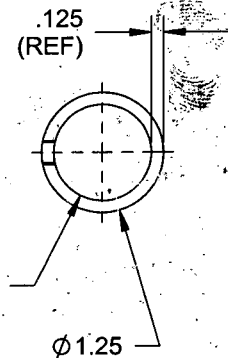
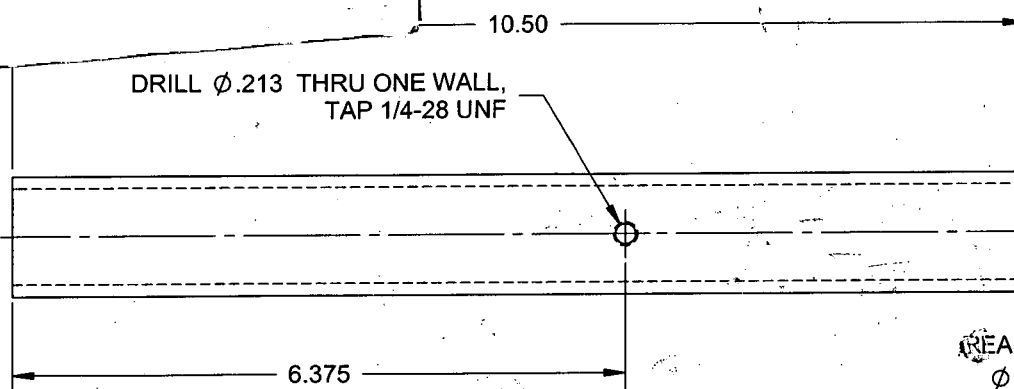
Count 2 EA

OR

Weight 1 LBS OZ

TAG # **26** INITIAL **[Signature]**

DART Inventory 25/02/05



M16332

M17270

D3353-13 TUBING

NOTES:

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING (REF. DART SPEC. M1020TR1.250W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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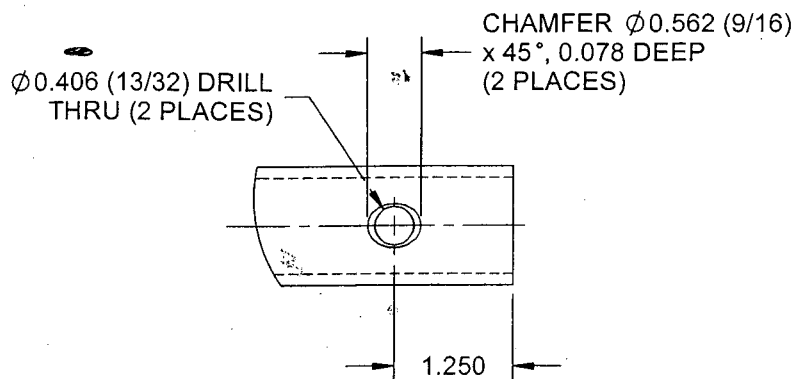
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0511

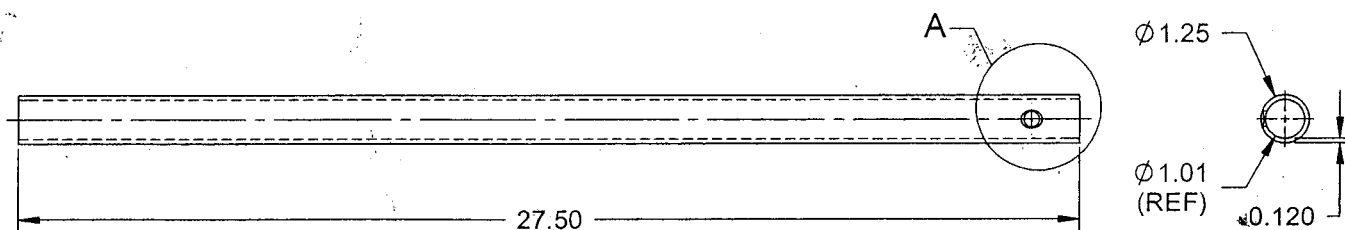
M1018 TR1.250 W.120 → ~~P~~ M1633Z

M1018 TR1.50 W.109 → M16444

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:5



DETAIL A
SCALE 1 : 2



PRELIMINARY ISSUE

D3355-5 MEDIUM TUBING

NOTES:

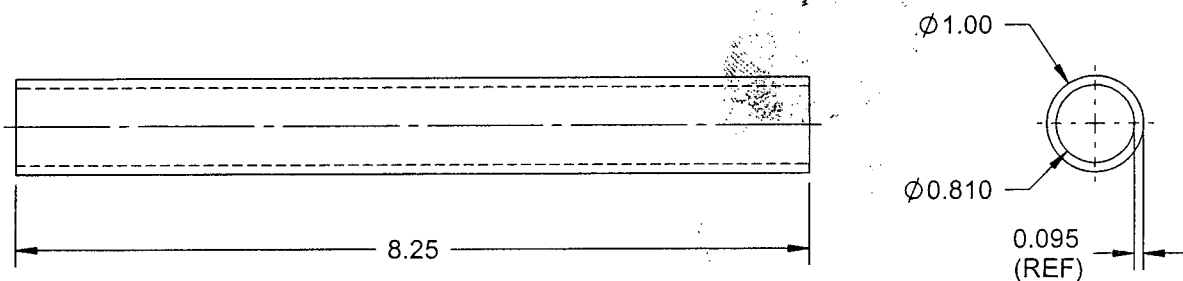
- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 7 OF 7
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:2

M16999



PRELIMINARY ISSUE

D3355-7 SMALL TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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1222110

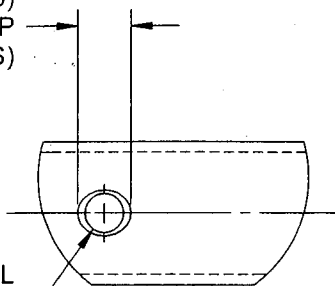
DART AEROSPACE LTD	Work Order:	P501-573
Description:	Part Number:	D3355-3
Dwg:	Qty:	1
		Page of

[illegible]

Rev	Date	Change	Revised By	Approved

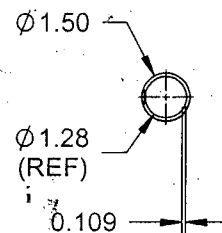
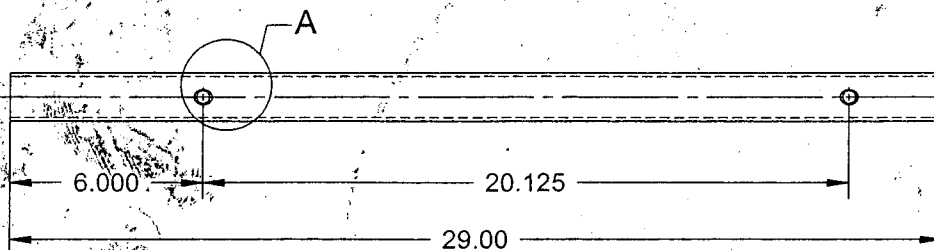
DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 5 OF 7
DATE 05.05.07		TITLE HANDLE WELDMENT	SCALE 1:6

CHAMFER $\phi 0.562$ (9/16)
x 45°, 0.078 DEEP
(2 PLACES)



$\phi 0.406$ (13/32) DRILL
THRU (2 PLACES)

DETAIL A
SCALE 1 : 2



PRELIMINARY ISSUE

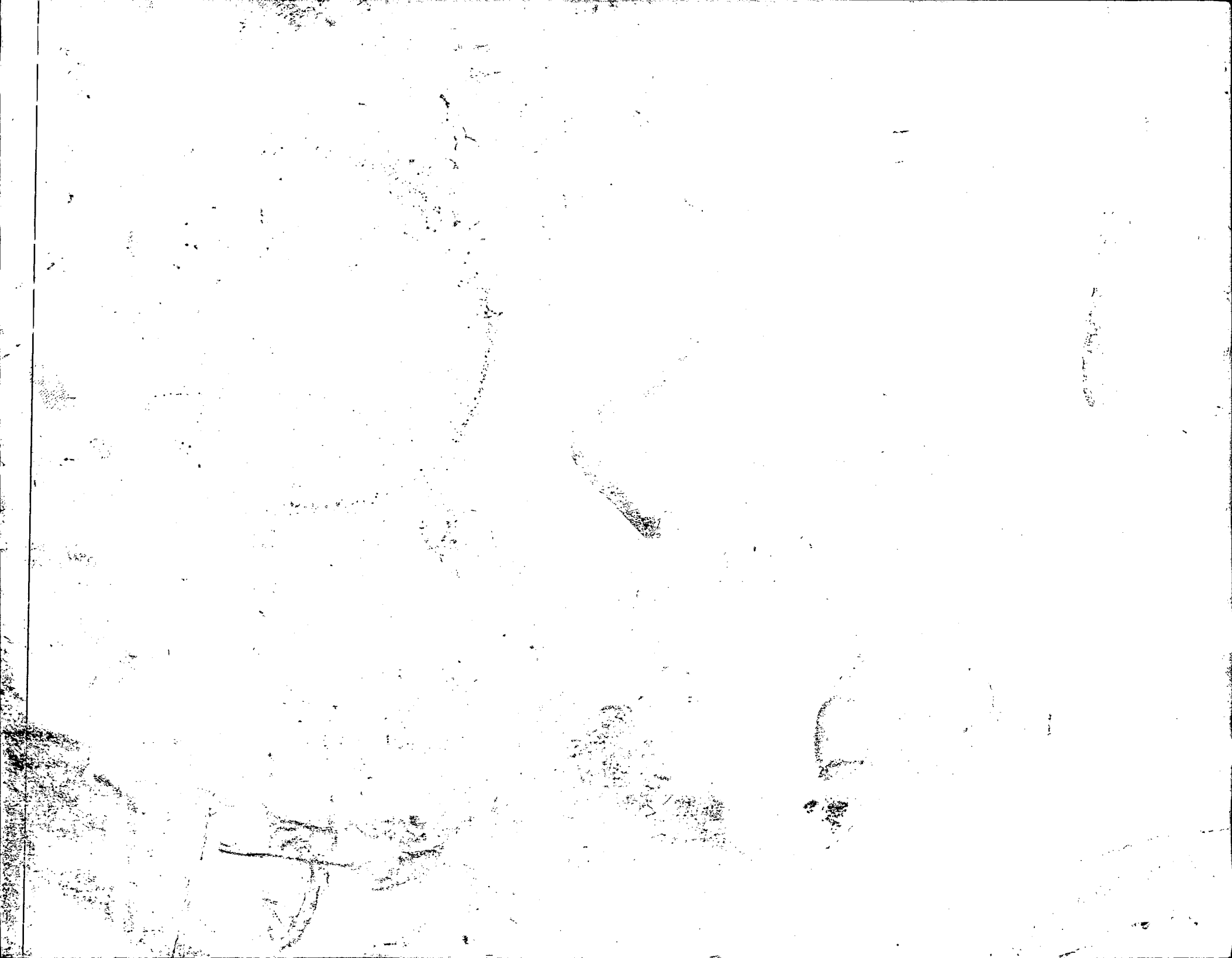
D3355-3 LARGE TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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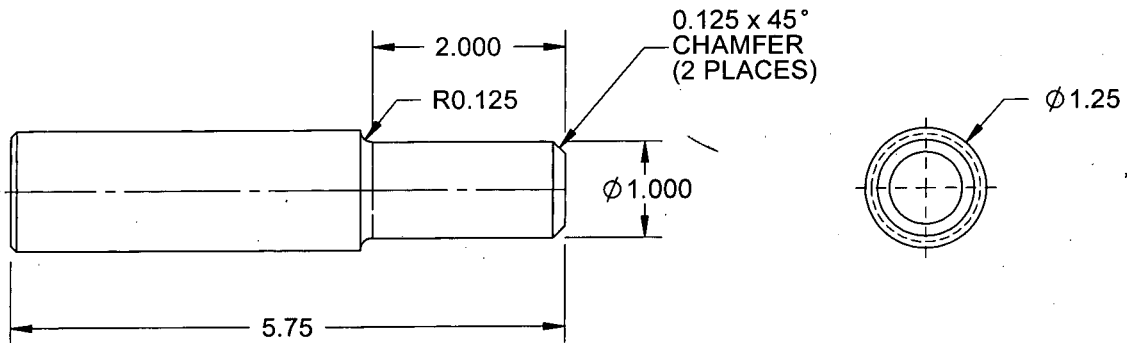


DART AEROSPACE LTD	Work Order:	P501-573
Description: HANDLE WELDMENT	Part Number:	D3355-043
Dwg:	Qty:	1
		Page of

[illegible]

Rev	Date	Change	Revised By	Approved

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 4 OF 7
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:2



PRELIMINARY ISSUE

D3355-1 HANDLE TIP

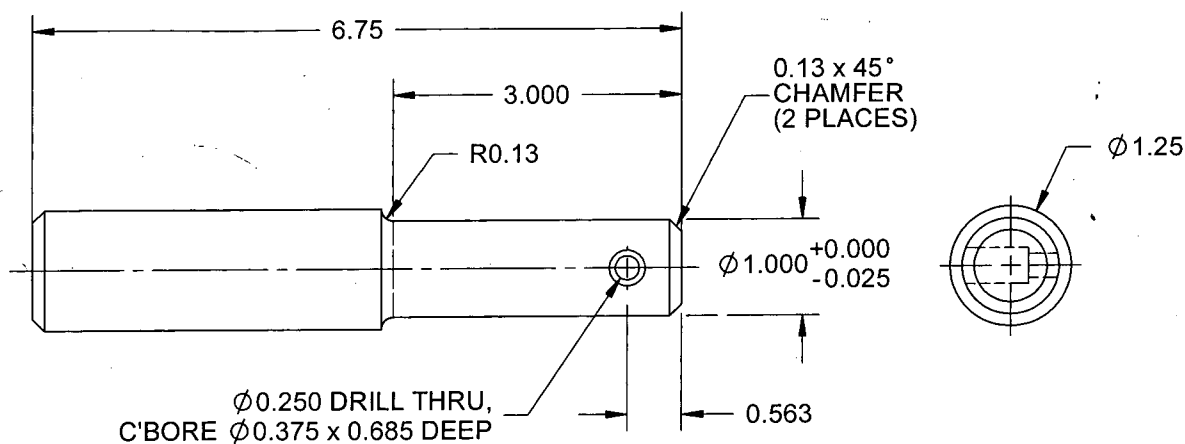
NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR, Ø 1.250
(REF. DART SPEC. M303R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 4 OF 7
DATE 05.02.07	TITLE HANDLE WELDMENT		SCALE 1:2



D3355-1 PIN

NOTES:

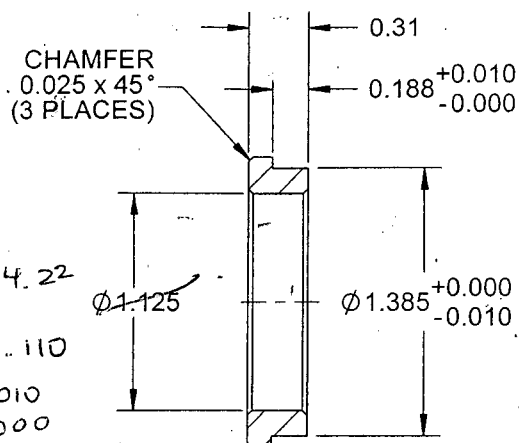
- 1) MATERIAL: AISI 303 ROUND BAR, $\phi 1.250$
(REF. DART SPEC. M303R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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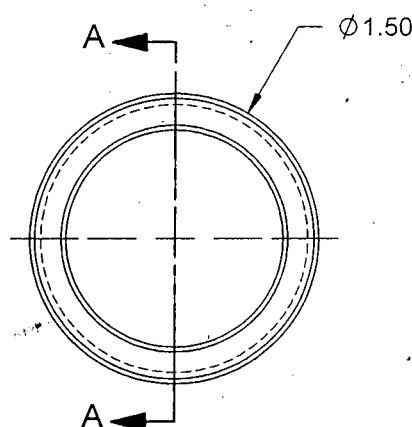
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3397	REV. A SHEET 2 OF 3
DATE 05.02.10	TITLE 12.5" WHEEL ASS'Y		SCALE 1:1

P601-371



SECTION A-A



M16332

PRELIMINARY ISSUE

D3397-3 FLANGED SPACER

NOTES:

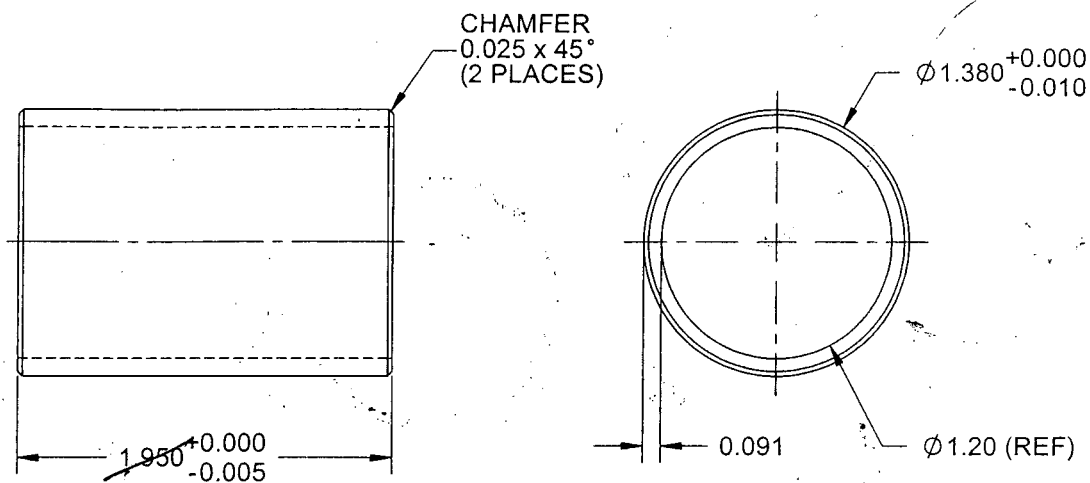
- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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382 N.

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3397	REV. A SHEET 3 OF 3
DATE 05.02.10		TITLE 12.5" WHEEL ASS'Y	SCALE 1:1



M17015

D3397-5 SLEEVE

PRELIMINARY ISSUE

NOTES:

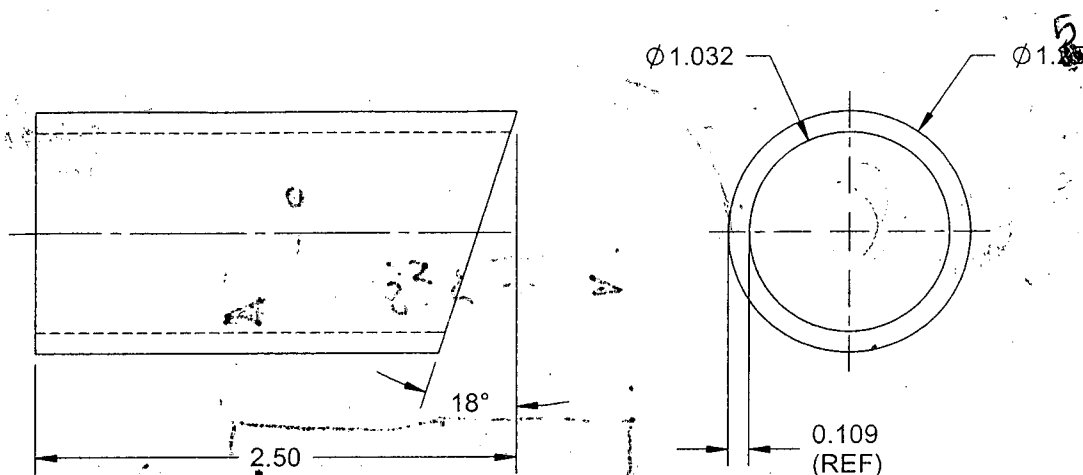
- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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DESIGN H	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3354	REV. A SHEET 7 OF 7
DATE 04.12.13		TITLE LEFT ARM WELDMENT	SCALE 1:1

M1018 TR 1.250 W .109
M16949



PRELIMINARY ISSUE

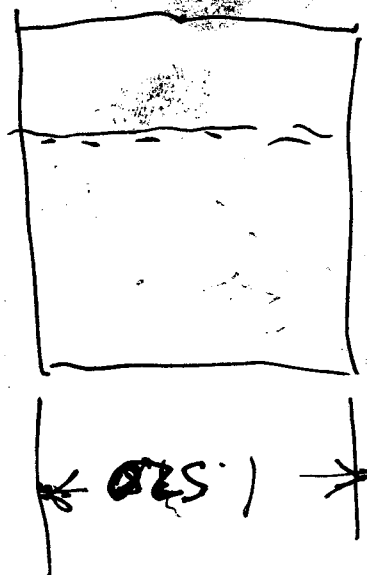
D3354-9 HANDLE SOCKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, Ø 1.25 x 0.109 WALL (REF. DART SPEC. M1020TR1.250W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020


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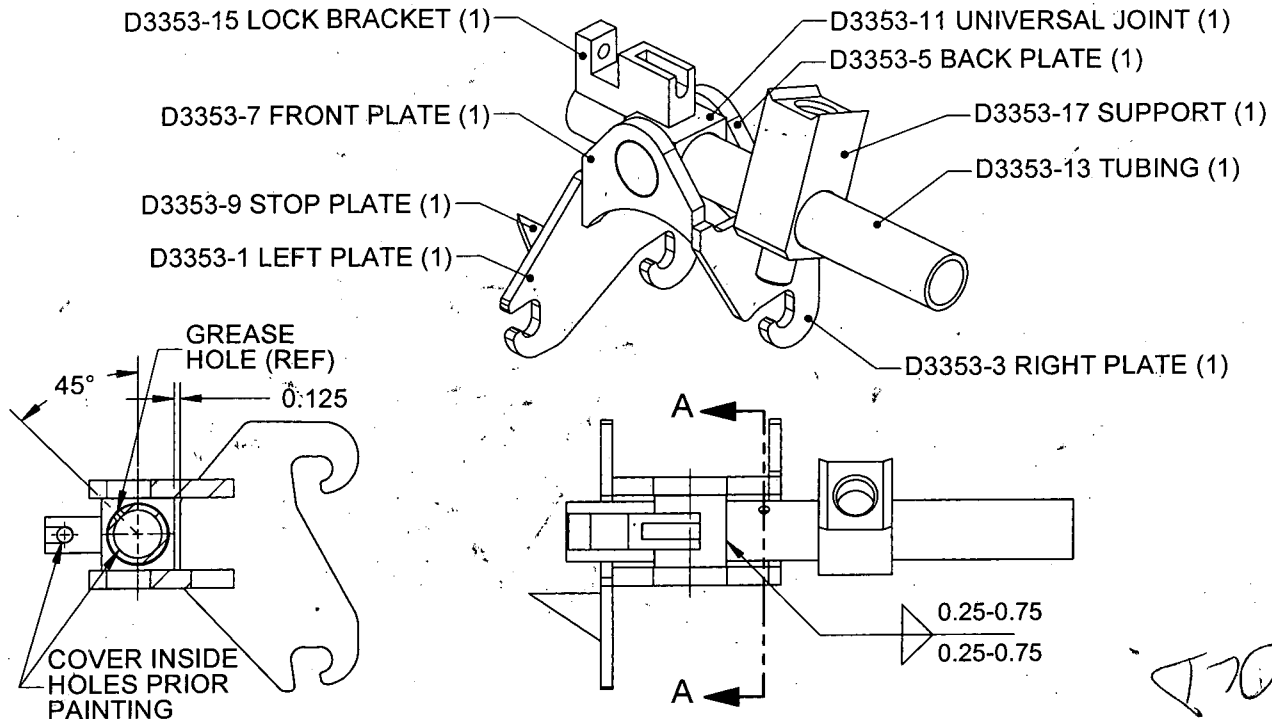
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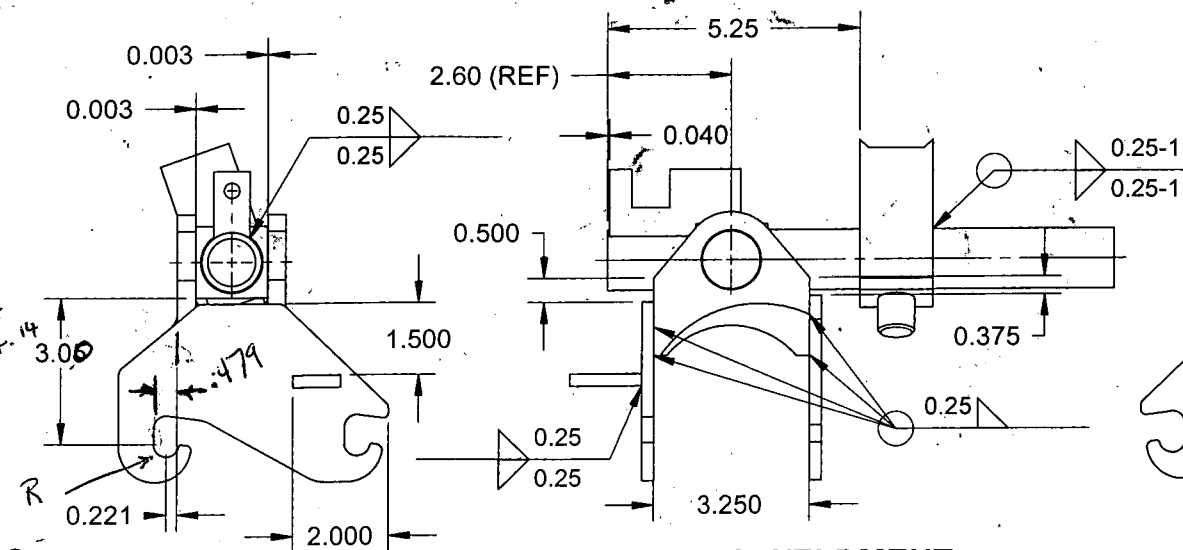
3.245
3.250

1.510

DESIGN 	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3353	REV. A SHEET 1 OF 10
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:4
A	04.12.14	NEW ISSUE	



SECTION A-A



Ro. 258

D3353-041 LUG WELDMENT


NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

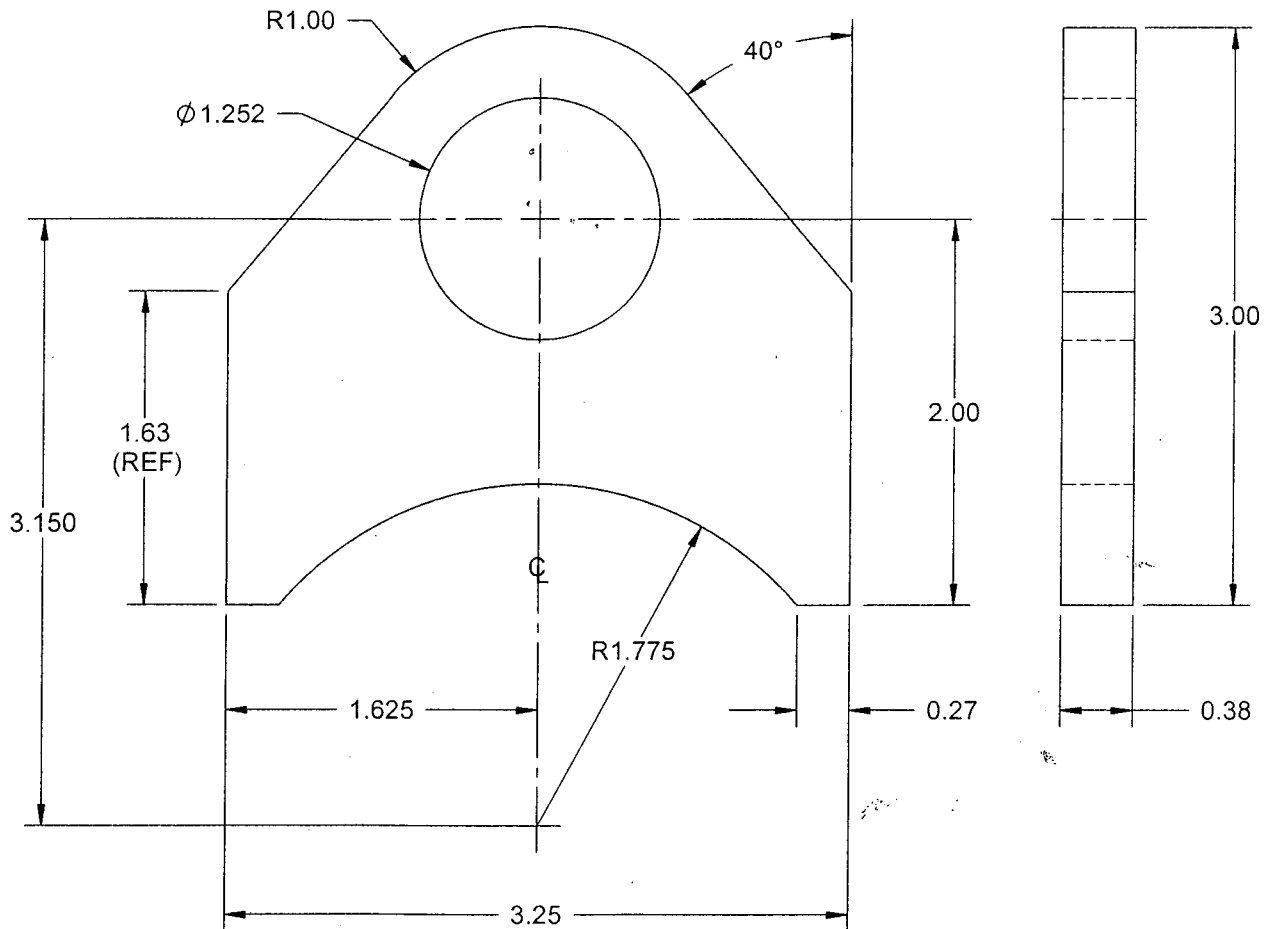
PRELIMINARY ISSUE

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CHECKED	APPROVED	DRAWING NO. D3353	REV. A SHEET 4 OF 10
DATE 04.12.13		TITLE LUG WELDMENT	SCALE 1:1

M16 387



PRELIMINARY ISSUE

D3353-5 BACK PLATE

NOTES:

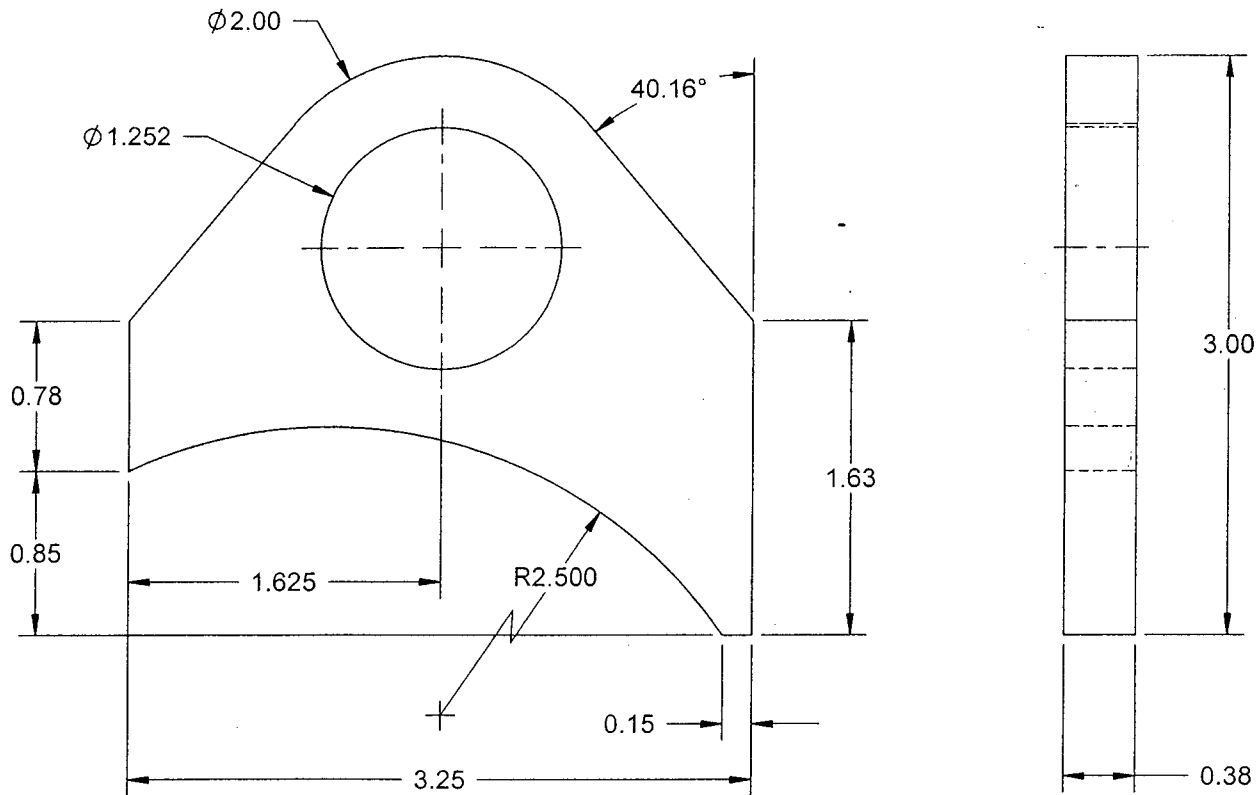
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES
STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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CHECKED	APPROVED	DRAWING NO. D3353	REV. A SHEET 5 OF 10
DATE 04.12.13		TITLE LUG WELDMENT	SCALE 1:1

M16387



PRELIMINARY ISSUE

D3353-7 FRONT PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR
CSA G40.21, 38W/44W/50W/60W/70W SERIES
STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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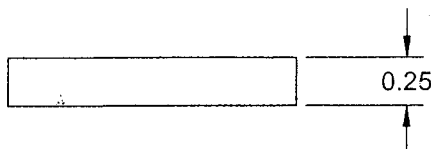
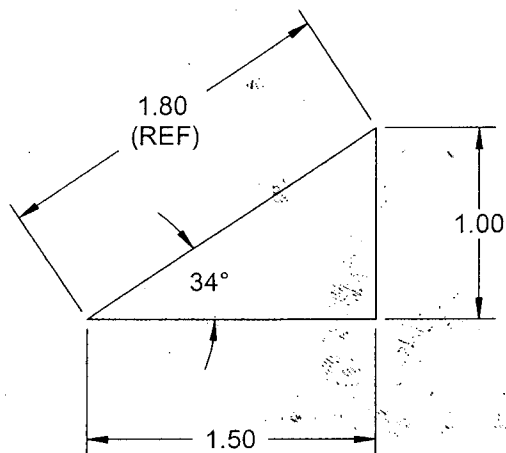
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CHECKED	APPROVED	DRAWING NO. D3353	REV. A SHEET 6 OF 10
DATE 04.12.13		TITLE LUG WELDMENT	SCALE 1:1

M1010-B0.250x01.250

M17014



PRELIMINARY ISSUE

D3353-9 STOP PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.25 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B0.250x01.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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